

Work Order ID 85954

June-19-12 8:03:27 AM

85954

Page 1

Item ID: D412-704-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Assembly (205/212/214/412)

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/19* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-704-041

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble pedal as per Dwg D412-704-041
Tighten & Torque Bolts as per Dwg D412-704-041

JB

5x
CL 12-7-3
(white label only)
12/07/13

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8/12/07/13

(+5)

120

Pick Kit

0.00

120

Packaging

Memo

0.00

Packaging

5

JB 12/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

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NS1

Revision ID:

Stop

NS2

Item Name: Pedal Assembly (205/212/214/412)

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Required Date: 03/07/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Memo

0.00

6/26/12

(P)

Quality Control

140

Identify as per dwg & Stock Location: *51003* 0.00

140

Packaging

Memo

0.00

Packaging

PAD 88 05 40
80452 1x

6/26/12

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

Quality Control

12/1/13

ME
12-07-03

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Picklist Print

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF
IPP Rev:C06.03.08 Re-format EC
IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC
IPP Rev:F 08-10-08 as per revB DD veriified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A *AN3-10A* Bolt		Purchased	No			100	Each	139.0000	1	4		12/06/29	
				<u>Location</u>				<u>Loc Qty</u>					
				GA				8					
				119084				8					
				ST351				131					
				117795				2					
				120873				129					
AN315-4R *AN315-4R* Nut		Purchased	No			100	Each	23.0000	1	4		12/06/29	
				<u>Location</u>				<u>Loc Qty</u>					
				ST344				23					
				17566				23					
AN4-10A *AN4-10A* Bolt		Purchased	No			100	Each	77.0000	1	4		12/06/29	
				<u>Location</u>				<u>Loc Qty</u>					
				ST356				77					
				117619				27					
				121666				50					

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Page 2

Work Order ID: 85954

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

85954

D412-704-041

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-12A Purchased No

100 Each 534.0000 2 8

AN4-12A

Bolt

**

GP 12/06/29

Location

Loc Qty

Loc Code

ST357

534

115422

4

119775

28

120423

477

121524

25

10

AN4-13A Purchased No

100 Each 1,260.000 1 4

AN4-13A

Bolt

**

GP 12/06/29

Location

Loc Qty

Loc Code

ST357

1260

120187

19

120422

2

120770

19

121652

1000

122063

220

5

AN960JD10 NAS1149D0363J Purchased No

100 Each 0.0000 5 20

AN960.ID10

Washer

**

GP 12/06/29

AN960JD416 NAS1149D0463J Purchased No

100 Each 30.0000 11 44

AN960.ID416

Washer

**

GP 12/06/29

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

55

112/19/12 55

June-19-12 8:03:31 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-704-041

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Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00



AN960JD416L

NAS1149D0416J Purchased

No

100

Each

6.0000

3

12

AN960JD416L

Washer

40 M120910 (120)

Location

Loc Qty

Loc Code

FP002

6

110153

6

D3204-041

Manufactured

No

100

Each

2.0000

1

4

D3204-041

Release Pedal Assembly

Location

Loc Qty

Loc Code

GA

2

82593

2

D3205-1

Manufactured

No

100

Each

8.0000

1

4

D3205-1

Pedal Bracket

Location

Loc Qty

Loc Code

GA

8

83937

8

D3205-3

Manufactured

No

100

Each

7.0000

1

4

D3205-3

Back Plate

Location

Loc Qty

Loc Code

GA

7

82060

2

83991

5

**

**

**

**

EB 12/06/29

EB 12/06/29

D83936 (32)

2 EB 12/06/29

5 EB 12/06/29

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Pieclist Print

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3206-1 Manufactured No

100 Each 7.0000 1 4

D3206-1

Pedal Arm

**

Location

Loc Qty

Loc Code

ST

7

83938

7

D3209-041 Manufactured No

100 Each 5.0000 1 4

D3209-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

GA

5

79805

5

MS21042L3 Purchased No

100 Each 1,736.000 1 4

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

1736

115835

4

117885

32

119017

816

119075

138

121349

15

121444

731

MS21042L4 Purchased No

100 Each 2,930.000 5 20

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

2930

119075

116

121011

193

121444

2321

121652

300

June-19-12 8:03:32 AM

Shop Packet Print

Page 4

EP 12/06/12
B73469
#2
EP 12/06/12
EP 12/06/12
5
EP 12/06/12
25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS24694-S102

Purchased

No

100

Each

21.0000

1

4

MS24694-S102

**

EP 12/06/12

Screw

Location

Loc Qty

Loc Code

ST289A

21

114382

21

MS9519-10

Purchased

No

100

Each

7.0000

1

4

MS9519-10

**

EP 12/06/12

Bolt

Location

Loc Qty

Loc Code

ST296

7

100290

7

AN3-6A

Purchased

No

120

Each

256.0000

2

4

AN3-6A

**

M 122141 (12)
JB

S Bolt

Location

Loc Qty

Loc Code

ST351

256

117441

36

120644

70

121060

50

121166

100

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

4

4

***AN960.ID10I ***

**

120644
121708 JB 12/07/03

S Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

120

Each

1,736.000

2

810 ✓

**

JO 12/07/03

8 *MS21042L3*
Nut

Location

Loc Qty

Loc Code

ST300

1736

115835

4

117885

32

119017

816

119075

138

121349

15

121444

731

121444

Dart Aerospace Ltd

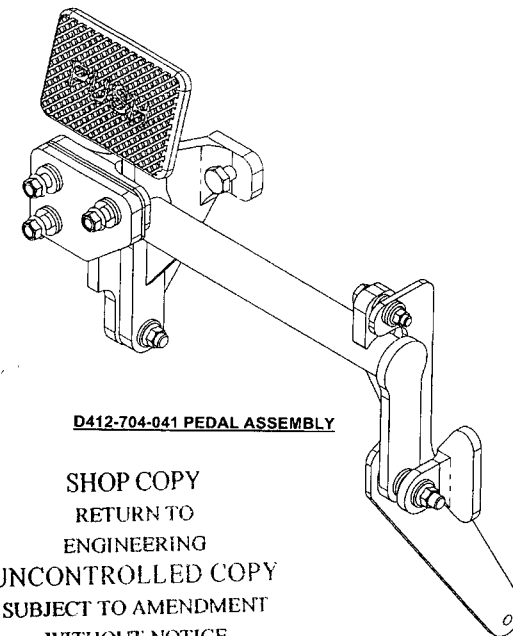
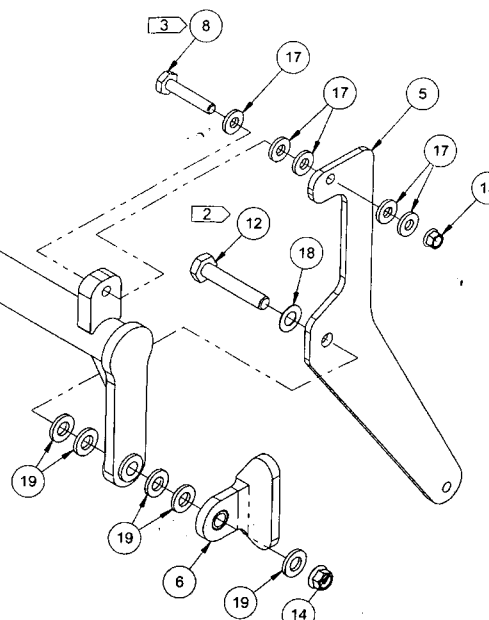
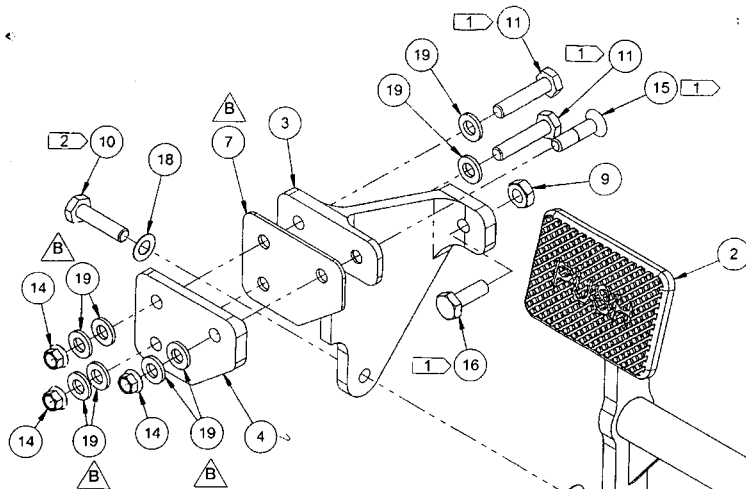
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D412-704-041 PEDAL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 0575YMLJ
12/06/19

RELEASED
2012-03-21
PER ECN 12-545 CP

PARTS LIST:

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D412-704-041	PEDAL ASSEMBLY
2	1	D3204-041	PEDAL ASSEMBLY
3	1	D3205-1	PEDAL BRACKET
4	1	D3205-3	BACK PLATE
5	1	D3206-1	PEDAL ARM
6	1	D3209-041	BRACKET ASSEMBLY
7	1	D4610-5	SHIM
8	1	AN3-10A	BOLT
9	1	AN315-4R	NUT
10	1	AN4-10A	BOLT
11	2	AN4-11A	BOLT
12	1	AN4-13A	BOLT
13	1	MS21042L3	NUT (OR MS21042-3)
14	5	MS21042L4	NUT (OR MS21042-4)
15	1	MS24694-S102	SCREW
16	1	MS9519-10	BOLT
17	5	NAS1149D0363J	WASHER (OR AN960JD10)
18	3	NAS1149D0416J	WASHER (OR AN960JD416L)
19	14	NAS1149D0463J	WASHER (OR AN960JD416)
N/A*	2	AN3-6A	BOLT
N/A*	4	NAS1149D0332J	WASHER (OR AN960JD10L)
N/A*	2	MS21042L3	NUT (OR MS21042-3)

EXPLODED ASSEMBLY VIEW

NOTES:

- 1) INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2) TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3) TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

B	ADD D4610-5 (ZN D8-1); ADD WASHER (ZN A6-1, B6-1, C8-1, D8-1), AN4-11A WAS AN4-12A (ZN B6-1)	RF	12.02.24
A	NEW ISSUE	CB	07.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	ED	DRAWING NO.	REV. B
MFG-APPR	ED	D412-704-041	SHEET 1 OF 1
APPROVED	ED	TITLE	SCALE
DATE	12.02.24	PEDAL ASSEMBLY	PERCENTS

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